

Work Order ID 55293

January 13, 2010 9:01:31 AM

Handwritten signature



Page 1

Item ID: D3946-1

Accept



Setup Start



Revision ID:

Item Name: Panel, Center Post

Stop



Start Date: 1/13/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3946

A

100

0.00



HAND FINISHING THERMOFORMING

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut Blanks to fit frame size

Handwritten: OL 10/01/13 (X1)

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-up

2-Pre-heat tool

3-Thermoform as per Dwg. D3646-1 and Folio FTA 043 using tool DT948311

Dwg. Rev. A

Folio Rev. A

Handwritten: OL 10/01/13 (X1)

Work Order ID 55293

January 13, 2010 9:01:31 AM



Page 2

Item ID: D3946-1

Accept



Setup Start



Revision ID:

Item Name: Panel, Center Post

Stop



Start Date: 1/13/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control	Visually inspect for proper formation of each part								
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
140	HAND FINISHING THERMOFORMING	0.00							
Thermoform	Memo	0.00							
Thermoforming Machine	Trim to Finished Dimensions as per dwg D3946-1								

DL 10/01/13 (X1)

BB 10/01/13 (X1)

DL 10/01/13 (X1)

Work Order ID 55293

January 13, 2010 9:01:31 AM



Page 3

Item ID: D3946-1

Accept



Setup Start



Revision ID:

Item Name: Panel, Center Post

Stop



Start Date: 1/13/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Check dimensions to ensure conformity to drawing tolerances.

Ph. 10/01/14 (K)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Ph. 10-4-11

170

Identify as per dwg & Stock Location: **FAI**

0.00



Packaging

Memo

0.00

Packaging

W

Ph. 1

Work Order ID 55293

January 13, 2010 9:01:32 AM



Page 4

Item ID: D3946-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Center Post

Start Date: 1/13/10

Start Qty: 1.00



Cust Item ID:

Required Date: 1/15/10

Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

1062/02 JA

WF

10-02-01

00100 f/b

Picklist Print

January 13, 2010 9:01:30 AM

Page 1

Work Order ID: 55293



Parent Item: D3946-1



Parent Item Name: Panel, Center Post

Start Date: 1/13/10

Required Date: 1/15/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	749.8927	3.4789			



GE PLASTICS LEXAN SHEET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

749.8926526

107574

16.62

111973

190.526053

112176

542.7466

1 at. 3.3050 ~~10.000~~ sq ft. *OK* 10/01/13

DART AEROSPACE LTD		Work Order: 55293
Description: Panel, Center Post		Part Number: D3946-1
Inspection Dwg: D3946	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

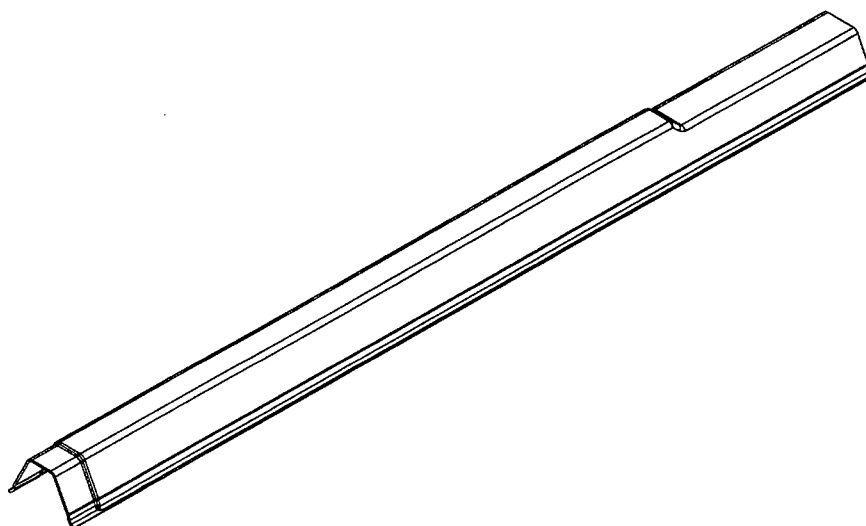
Measured by: OK Date: 10/01/13

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.25	REF	39.5"	✓			
1.25	REF	1.5"	✓			
3.2	REF	3.37"	✓			
0.070	Min	0.078"	✓			

Measured by: OK Date: 10/01/14
 Audited by: DB Date: 10/01/14
 Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>DB</u>



10,5293

D3946-1 PANEL, CENTER POST

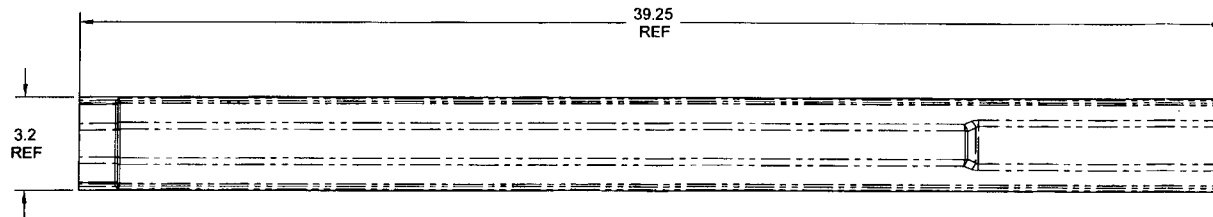
RELEASED
09/05/19

NOTES:

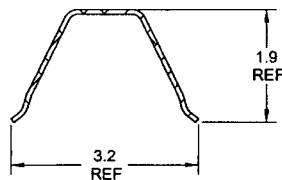
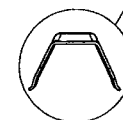
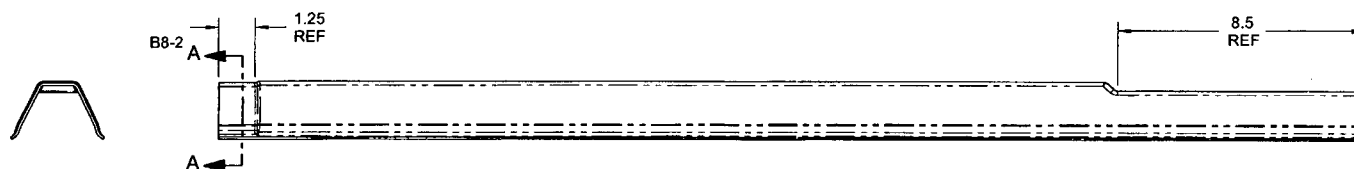
- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3946-1" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.74 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9483 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.070" UNLESS OTHERWISE NOTED

A	NEW ISSUE	PH	09.05.19
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3946	SHEET 1 OF 2
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	PANEL, CENTER POST	NTS
DATE	09.05.19	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



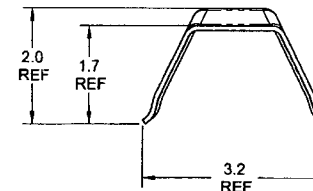
RELEASED
2/16/14



SECTION A-A C7-2
SCALE 2X

D3946-1 PANEL, CENTER POST

55293



DETAIL B C1-2
SCALE 2X

DESIGN	g	DART AEROSPACE LTD	
DRAWN	g	HAWKESBURY, ONTARIO, CANADA	
CHECKED	g	DRAWING NO.	REV. A
MFG. APPR.	g	D3946	SHEET 2 OF 2
APPROVED	g	TITLE	SCALE
DE APPR.	g	PANEL, CENTER POST	NTS
DATE	09.05.19	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT BE NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1